Ship Sept 14

Work Order ID 73641

Thursday, September 08, 2011 1:23:24 PM

Item ID: D3043-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3043	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Large Fab	0.00							
Large Fab	Memo	0.00	Ae	11.09.08		X	Ø		
Large Fab	1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G□2-Deburr and bevel ends for welding								
110	~~QC5~~ Qc 6 - Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00		11.09.09					
Quality Control									
120	Large Fab	0.00							
Large Fab	Memo	0.00		11.09.09		1	Ø		
Large Fab	1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808□AR AL ROD Batch: 117514 117884 □2-Grind Fwd End Cap weld flush								

PTO

Dart Aerospace Ltd

W/O: 73641	WORK ORDER CHANGES						
DATE	STEP	Perm. change PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.09.09	110	CHANGE TO QC 6	[illegible]	11.09.14	N/A	N/A	[illegible] 11/09/13

Part No: D3043-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73641

Thursday, September 08, 2011 1:23:24 PM

Item ID: D3043-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00				1	0	8E 11/09/12	
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	Su 09/12			1 RM			
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	11.09.12			1	0		
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73641

Thursday, September 08, 2011 1:23:24 PM

Item ID: D3043-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Large Fab	0.00							
Large Fab						1	Ø		
Large Fab	**Memo**	0.00							
	1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043□AR AL ROD Batch: 114519 □2-Inspect for foreign object as per QSI 024□3-Grind Fwd End Cap weld flush								
170	~~QC9~~ QC10- Inspect visual per QSI004- Fusion Welds	0.00							
QC						~~1~~ RY			Pto
Quality Control	**Memo**	0.00							
180	QC5- Inspect part completeness to step on W/O	0.00							
QC						~~1~~ RY			
Quality Control	**Memo**	0.00							

11.09.12

11.09.12

S 11/01/13

S 11/01/13

Dart Aerospace Ltd

W/O: 73641	Pen chg	WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
11/9/13	TR 170	change to QC 10 inspection level		11.09.14	N/A	N/A	11/09/13

Part No: D3043-042 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73641

Thursday, September 08, 2011 1:23:24 PM

Item ID: D3043-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									
200	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 9:15 ☐OVEN TEMPERATURE: 320°F ☐FINISH TIME: 9:45								

1X Ø M-L 11/09/13

1 Ø M 11/09/13

1X Ø M-L 11/09/13

M117745

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73641

Thursday, September 08, 2011 1:23:24 PM

Item ID: D3043-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	~~Pressure Wash per QS1005-4~~.3	0.00							PTO
HandFinish	WING WALK. QS PER DWG QS1005 4.4 BATCH: 11833.					1	BK 11-9-13.		
Hand Finishing	Memo	0.00							
230	QC3- Inspect Part Finish	0.00							
QC						IRH	ϕ	ll	11/09/13
Quality Control	Memo	0.00							
240	Identify as per dwg & Stock Location:_____	0.00							
Packaging									
Packaging	Memo	0.00							

Dart Aerospace Ltd

W/O: 73641		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-9-13	220.	CHANGE FOR WING WALK. PERMANENT CHANGE.	BK	11-9-13	1	N/A	11/9/14

Part No: D3043-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73641

Thursday, September 08, 2011 1:23:24 PM

Item ID: D3043-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00							

11/9/14

MF

11-09-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, September 08, 2011 1:23:21 PM

Work Order ID: 73641

Parent Item: D3043-042

Parent Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			120	Each	189.2000	1	1	Ae 11·09·08		
				Location		**Loc Qty**		**Loc Code**					
				HALL		179.5							
					64409	6							
					68293	56.5				(x1)			
					72131	117							
				WA		9.7							
					46910	2							
					66970	7.7							
D2734 Step End Plate		Manufactured	No			120	Each	74.0000	2	2	11·09·09		
				Location		**Loc Qty**		**Loc Code**					
				WA		74							
					70701	29				2			
					73196	45							
D3040-1 Mounting Lug		Manufactured	No			120	Each	22.0000	2	2	11·09·09		
				Location		**Loc Qty**		**Loc Code**					
				WA018		22							
					48239	22				2			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, September 08, 2011 1:23:21 PM

Work Order ID: 73641

Parent Item: D3043-042

Parent Item Name: Step Weldment RH, A119

Start Date: 9/8/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3040-3 Mounting Lug	Manufactured	No	100	Each	18.0000	2	2	11·09·09

Location	Loc Qty	Loc Code
WA018	18	
48240	18	

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		**D3043-041**	**STEP WELDMENT, LH**
	X	**D3043-042**	**STEP WELDMENT, RH**
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

1) MANUFACTURE FROM D2622-120 EXTRUSION
2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
   POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP RADIUS PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O 73641

RELEASED 01.07.05

Copyright © 2001 by DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

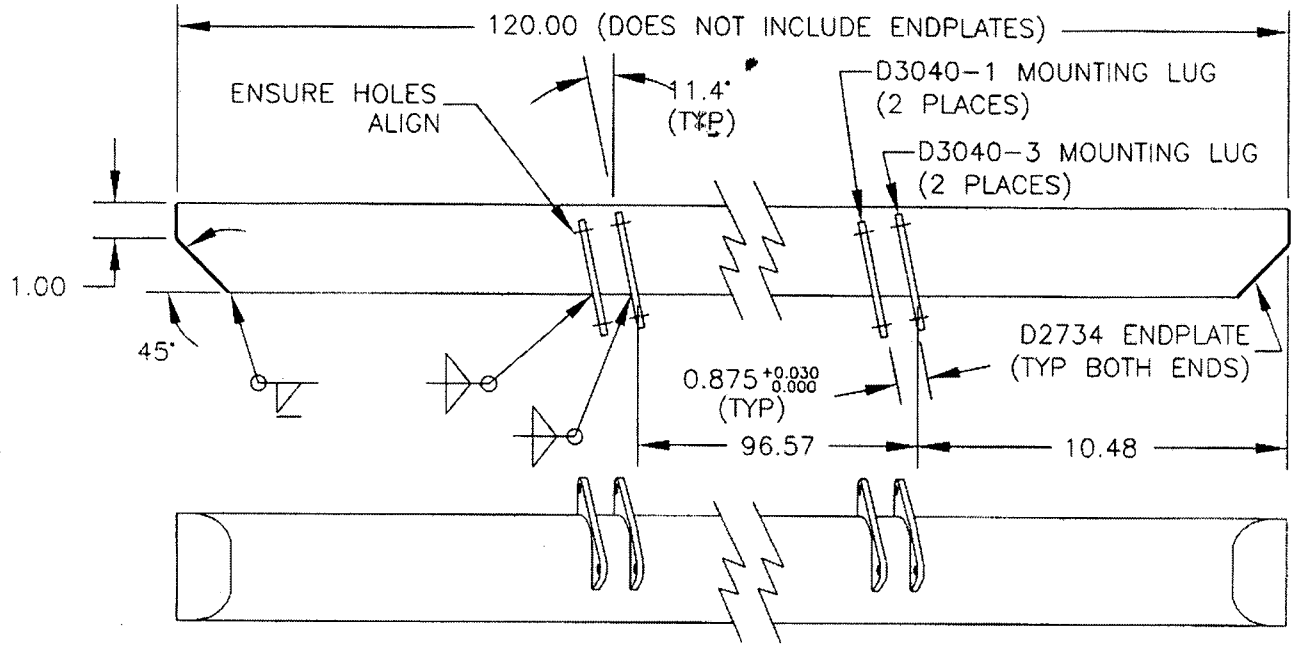
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

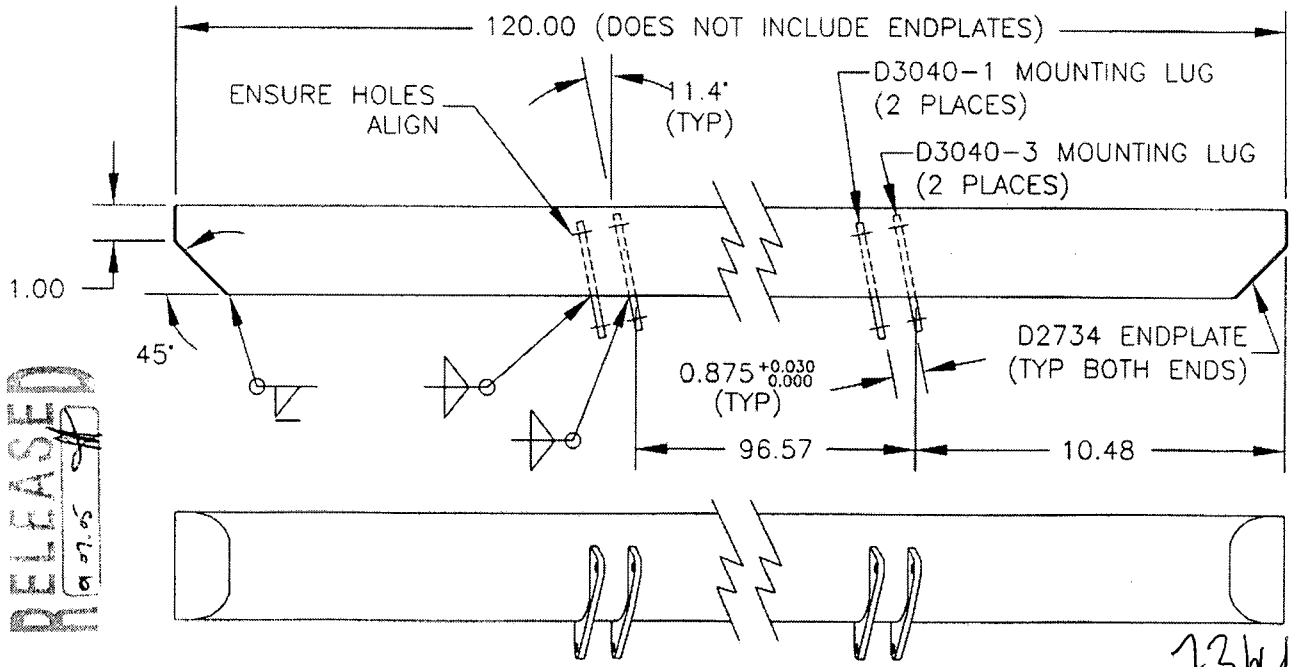
NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED 07.06

73611

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE